



Dart Aerospace Ltd.
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RBE350A93-3717-00

Job Sheet 185279



8/18
Dec 7

Part No: RBE350A93-3717-00

Job Qty: 1 ea

Part Name: Case Seal Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3717-00 Rev.B IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Small Fab	1 pcs	11/30/18	11/30/18	0.00	1.00	Small Fab-3		MLL DAS
120	QC	1 pcs	11/30/18	11/30/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1		Darant
140	QC21-FG	1 Ea	11/30/18	11/30/18	0.00	0.00	QC21		21

Part Op Descriptions: 110 - 1-Assemble as per DWG.

JAN 17 2019
GA 141B

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90591A151	Nuts	2 (2 ea)	90-Start up Operation	512242
91280A334	Hex Head Cap Screw	2 (2 ea)	90-Start up Operation	5122536
91455A120	Washer	2 Ea (2 ea)	90-Start up Operation	FM138444-C
RBE350A93-3717-00-01	Body	1 Ea (1 ea)	110-Small Fab	5132502
RBE350A93-3717-00-03	Half Receiver	2 Ea (2 ea)	110-Small Fab	5144265

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90591A151	2	0	0
	91280A334	2	0	0
	91455A120	2	97	0
	RBE350A93-3717-00-01	1	0	0
110-Small Fab	RBE350A93-3717-00-03	2	0	0



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ind.

Container No: S145213



Part: RBE350A93-3717-00

Job No: 185279

Serial No/Batch: S145213

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 01/16/19

Plex 10/24/18 1:20 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

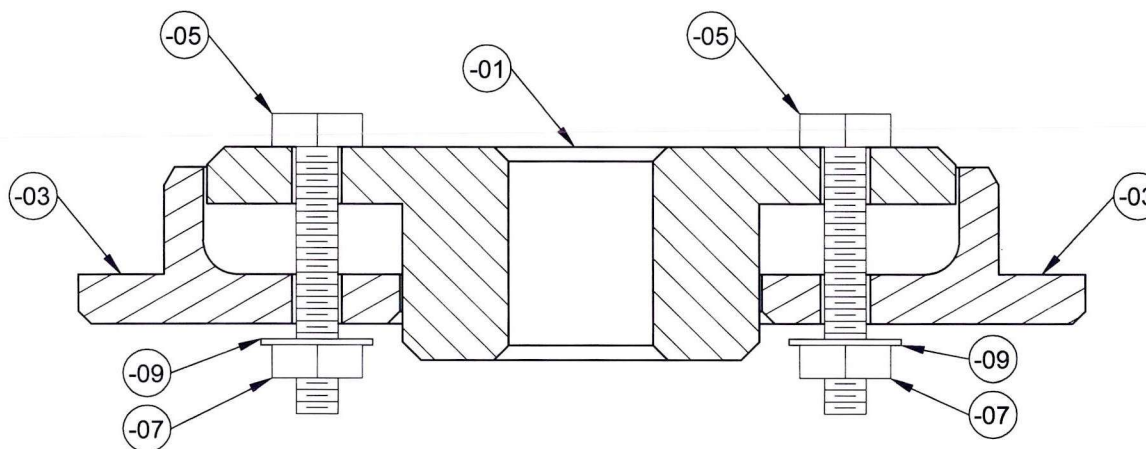
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185279 MJS
18-16-24

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
A	ADDED MISSING DIMENSIONS -01 & -03 PER S.E.	11/30/10	RJC
B	CH'D T/N WAS RBEA93-3717-00 IS RBE350A93-3717-00. -01 & -03 MOVED TO SEPARATE SHEETS, DELETED DUPLICATE DIMS, CH'D SPEC ON FINISH WAS MIL-C-81562B, TYPE II, CLASS I IS QQ-P-416F, TYPE II, CLASS I. -05 ADDED B/O INFO #91280A334. -07 ADDED B/O INFO #90591A151. -09 ADDED B/O INFO #91455A120. CH'D TOLERANCE ON NON-CRITICAL PARTS. -3 CH'D SPEC WAS Ø6 X 1-1/8 IS 1.0 X 4.5 X 5.50.	5/27/14	DPD



NOTES:

1. TEST PIECES R.C. 5
2. "AMGC9927" WAS ALSO ENGRAVED ON TOOL.

RED BARN MACHINE	
TITLE CASE SEAL REPLACEMENT TOOL	
DWG NO. RBE350A93-3717-00	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 XX ± .01 ANGLES ± .5° X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8-13-09
SHEET 1 of 3	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-01	1	BODY	1018	Ø4-1/2 X 1-3/8	2
			-03	2	HALF RECEIVER	1018	1.0 X 4.5 X 5.5 (MAKES TWO HALVES)	3
		B/O	-05	2	HEX HEAD CAP SCREW	STEEL	M6x1 X 25mm MCMaster-CARR #91280A334	1
		B/O	-07	2	NUTS	STEEL	M6x1 MCMaster-CARR #90591A151	1
		B/O	-09	2	WASHERS	STEEL	Ø6mm MCMaster-CARR #91455A120	1
ASSY #								